

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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X20 15 20/7/01/05
BEB

DQA: _____ Date: _____

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OTHER : ☐					

Work Order ID 154330

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154330

Page 3

Item ID: D3578-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Doubler**Start Date:** 12/9/2016 **Start Qty:** 20.00***20*****Cust Item ID:****Required Date:** 12/16/2016 **Req'd Qty:** 20.00***20*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.03

Quality Control

DAS
9
9-89

170

Small Fab

0.00

170

Small Fab

Memo

0.07

Small Fab

1-Assemble as per dwg D3578

DAS
36
9-89
20x 17/01/06

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.07

Quality Control

DAS
9
9-89

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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☐ OTHER : _____					

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Item ID: D3578-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 12/9/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/16/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: Stop

0.00

190

Packaging

Memo

0.03

Packaging

20

JAN 10 2017

DAS
6
9-89

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.33

Quality Control

DAS
21
9-89

JAN 10 2017

ME
17-1-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 154330

154330

Parent Item: D3578-041

D3578-041

Parent Item Name: Doubler

Start Date: 12/9/2016

Required Date: 12/16/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A07.04.11New issueEC
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080		Purchased			No	170	sf	107.1000	0.007	0.147368			
--------------	--	-----------	--	--	----	-----	----	----------	-------	----------	--	--	--

M6061T6S 080

6061-T6 .080 Sheet

02/16/12/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	107.1	
134217	9.1	
m132772	4.3	
m133587	7.7	
m133828	2.6	
m134551	7	
m134830	19.9	
m135147	18.07	
m135559	12.23	
m135861	26.2	

MS20426AD3-3

Purchased

No

110 Each 5,571.000 2 40

MS20426AD3-3

RIVET

17/01/06 DAS 36 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
fg108	480	
M134946	200	
M135354	120	
M135894	160	
GA	2250	
M135274	2250	
ST312	2841	
M135274	2841	

40

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 154330

154330

Parent Item: D3578-041

D3578-041

Parent Item Name: Doubler

Start Date: 12/9/2016

Required Date: 12/16/2016

Start Qty: 20.00

Required Qty: 20.00

MS21075L3 MS21075L3N Purchased

No

170

Each

244.0000

1

20

MS21075L3

17/01/06 DAS
36
9-89

Nut Plate

Location

Loc Qty

Loc Code

GA

22

m135774

22

ST298

222

m135774

22

m135908

200

20

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OTHER : ☐					

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WORK ORDER NON-CONFORMANCE / UPDATE

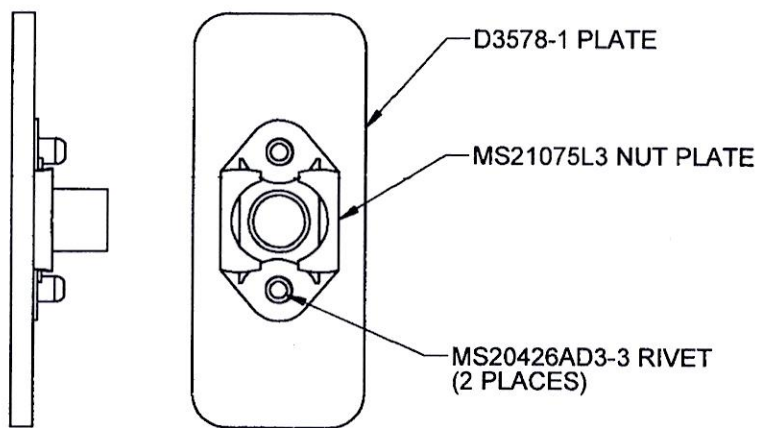
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OTHER : _____					



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



RELEASED
07.04.02

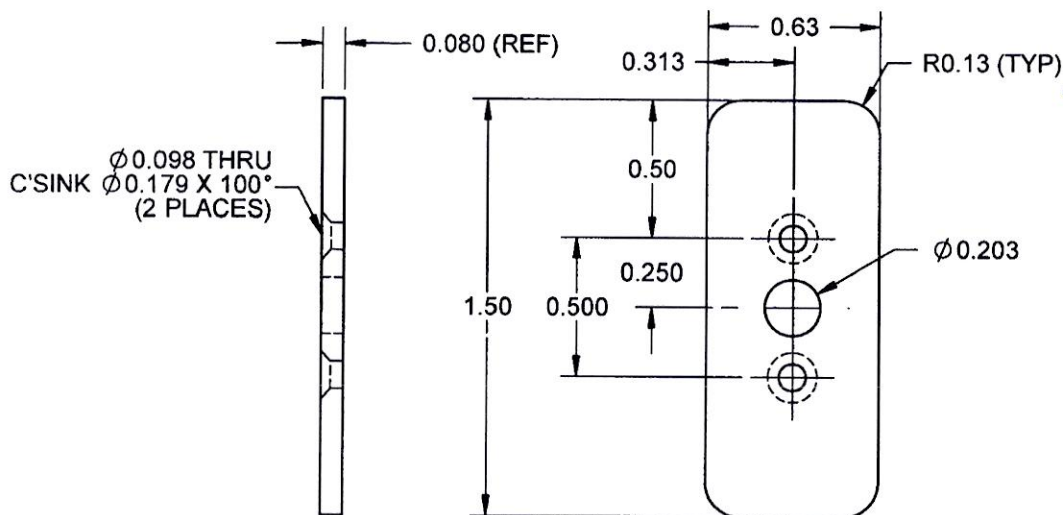
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

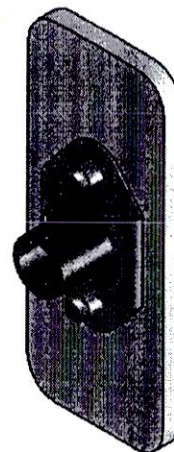
D3578-041 DOUBLER

D3578-041 NOTES:

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151330 M/C
10-12-08



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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